

8 7 6 5 4 3 2 1

D

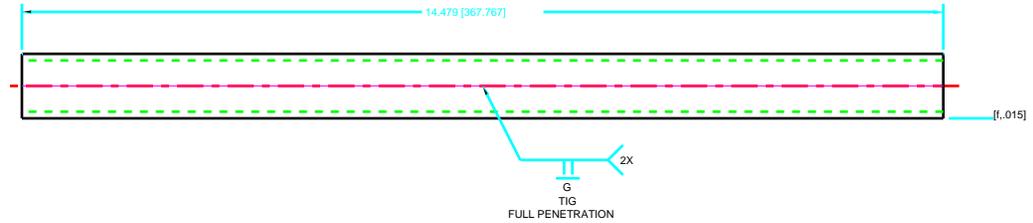
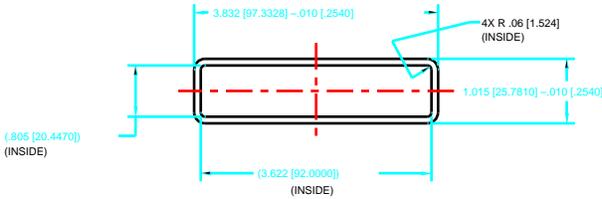
C

B

A

8 7 6 5 4 3 2 1

- NOTES:
1. WHEN MACHINING VACUUM PART, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
  2. THIS IS A UHV PART. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN.
  3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
  4. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REFERENCE ONLY.
  5. WALL THICKNESS NOT TO BE LESS THAN .100 AFTER MACHINING IF NEEDED.



ITEM	DWG. & ELECTRONIC FILE NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		ELECTRONIC FILE NUMBER <b>A09904</b>		
DECIMALS: <b>TOLERANCES:</b> <b>ANGULAR:</b> X - .015                      X - .015                      - 25 XX - .010                   XXX - .005		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ASME B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ASME Y14.5	DRAWN BY <b>RICK KRAKORA</b> 4/93 DATE	CHIEF DESIGN ENGINEER DATE	TITLE <b>ADVANCED PHOTON SOURCE            K2 BM FIRST COLLIMATOR            VACUUM CHAMBER            RECTANGULAR TUBING</b>	DATE
SURFACE ROUGHNESS   12.5	CHECKED BY DATE	PROJECT MGR. DATE	APPROVED/RELEASED DATE	DRAWING NUMBER <b>P4102020102-210101-00</b>
MATERIAL <b>12 GA. (.105)            304 SSST</b>	SCALE <b>1=1</b>	SIZE <b>D</b>	SHEET <b>1 of 1</b>	
DO NOT SCALE DRAWING	CHANGE DESCRIPTION                      BY                      CHD                      DATE			
REVISIONS	1			

PLOT SCALE: 1=1